

### **Amendments to the Claims**

This listing of claims will replace all prior versions, and listing, of claims in the application.

### **Listing of Claims:**

Claims 1-20. (Cancelled)

21. (Previously presented). A method for the milling-type machining of chipless materials for the manufacture of heat-resistant sand molds, said method comprising:  
providing a shank-end tool comprising:  
a shank portion having a longitudinal axis, a first end that can be connected detachably to a drive device and a second end with a groove-shaped recess extending in the longitudinal direction; and  
a blade as an insert tool in the form of a flat bar in said groove and fixedly attached to the shank, said cutter blade having a flat leading face with a leading blade edge in a direction of advance during use,  
wherein the blade has a leading blade edge with at least a portion of the leading edge substantially parallel to said longitudinal axis and the flat bar and is provided with a non-cutting blade edge on the leading face; and  
wherein said leading blade edge is at a right angle to the flat leading face; and  
machining a chipless material with the shank-end tool to provide a finished form.

22. (Previously presented). A method for the milling-type machining of chipless materials in accord with claim 21, wherein the flat leading face of the blade is more wear resistant than the rear side of the cutter blade, wherein the blade comprises a steel base material and is provided with a wear - protective covering on the leading flat face, the wear-protective covering being a material selected from the group consisting

of a hard substance, a metal composite containing hard substances, and a metal alloy containing a hard substance.

23. (Previously presented). A method for the milling-type machining of chipless materials in accord with Claim 21, wherein the blade further comprises a trailing edge behind the leading blade edge when viewed in the direction of advance, wherein the blade edge and the trailing edge are rounded.

24. (Previously presented). A method for the milling-type machining of chipless materials in accord with Claim 21, wherein the flat leading face of the blade has a rounded corner or a corner cut at an angle.

25. (Previously presented). A method for the milling-type machining of chipless materials in accord with Claim 21, wherein the flat leading face of the blade has an outer contour with a circular arc or conical shape.

26. (Previously presented). A method for the milling-type machining of chipless materials in accord with Claim 21, wherein the blade further comprises a curved surface having a convex face or a bent surface, parallel to the longitudinal axis, with the convex face of the curved surface or of the bend pointing in a direction of rotation of the shank in use.

27. (Previously presented). A method for the milling-type machining of chipless materials in accord with Claim 21, wherein the blade further comprises shovel-like blade folds that are sloped with a blade angle relative to the longitudinal axis to produce fan-like action.

28. (Previously presented). A method for the milling-type machining of chipless materials in accord with Claim 21, wherein the blade comprises a material selected from the group consisting of a metal, a high-strength elastically deformable material,

and a springy material.

29. (Canceled).

30. (Previously presented). A method for the milling-type machining of chipless materials in accord with Claim 21, wherein the shank comprises a tubular or cylindrical hollow body at least at the second end.